

Work Order ID 86475

June-29-12 4:30:11 PM

\*86475\*

Page 1

Item ID: D4545-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Retainer, Inner, LH (Lower)

Start Date: 29/06/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: *MC*

Date: 12/06/29 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4545	C								
100	Pick Kit	0.00							
*100*									
Packaging	Memo	0.00							
Packaging									
110		0.00							
*110*									
Small Fab	Memo	0.00							
Small Fab	1- ASSEMBLE AND BEND TABS AS PER DWG								
	2- DISASSEMBLE AND DEBURR								
	3- DIMPLE HOLES AS PER DWG								

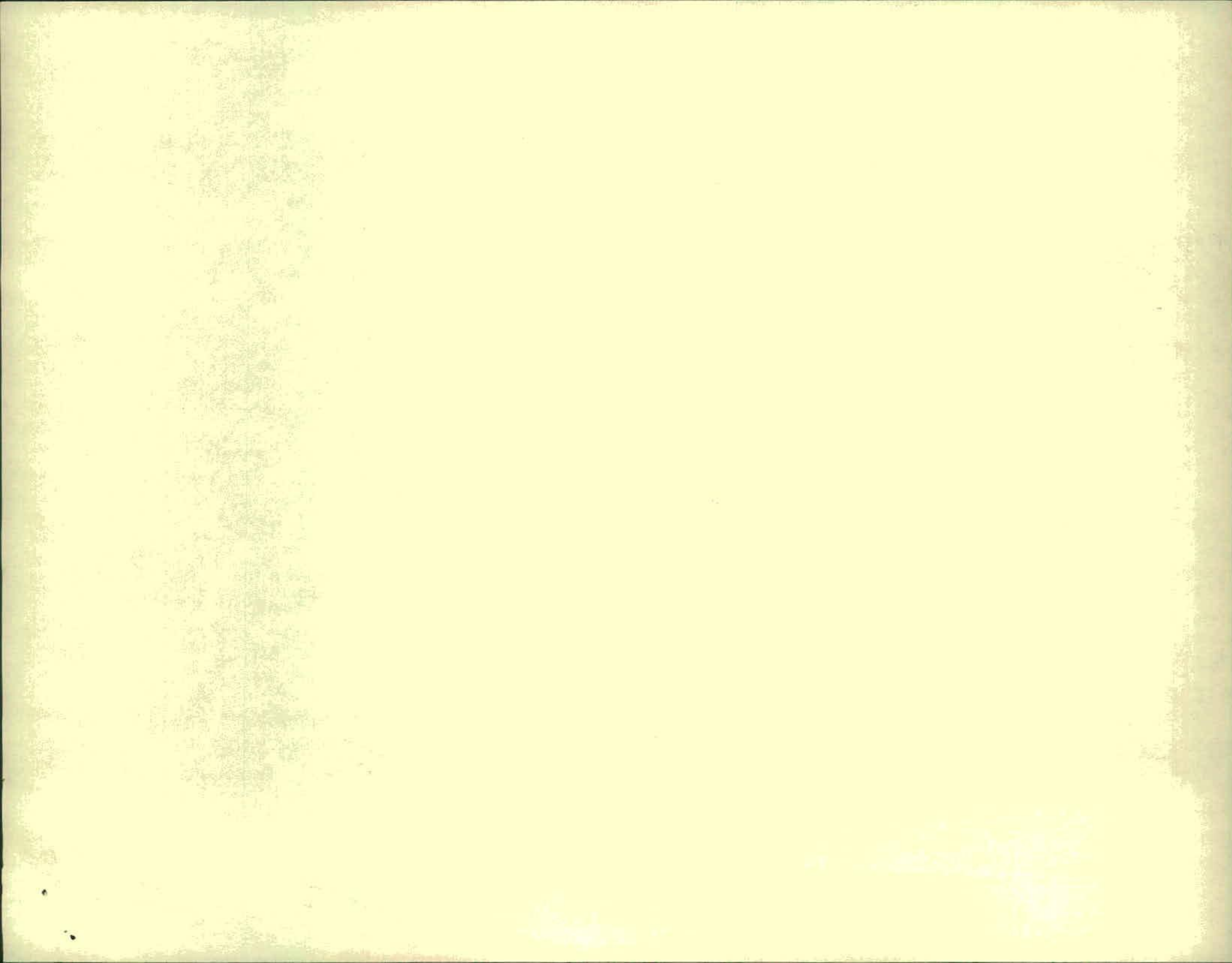
10

10

6x

*[Signature]*

*[Signature]*  
12/07/24



Work Order ID 86475

\*86475\*

Page 2

June-29-12 1:30:11 PM

Item ID: D4545-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Retainer, Inner, LH (Lower)

Start Date: 29/06/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

Quality Control

0.00

130

Chemical Conversion Coat per QSI005 4.1

0.00

\*130\*

HandFinish

Memo

Hand Finishing

0.00

140

QC7-Inspect Chemical Conversion Coat

0.00

\*140\*

QC

Memo

Quality Control

0.00

Smb  
12-8-31  
DAS  
16  
1262/31

6x φ

M-F  
12/08/31

6x φ M 11/08/31





# Work Order ID 86475

\*86475\*

Page 3

June-29-12 1:30:11 PM

Item ID: D4545-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Retainer, Inner, LH (Lower)

Start Date: 29/06/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

145

0.00

\*145\*

Small Fab

Memo

0.00

Small Fab

INSTALL NUT PLATES AND ASSEMBLE AS PER DWG

6x

12/09/04

147

QCS-Inspect part completeness to step on W/O

0.00

\*147\*

QC

Memo

0.00

Quality Control

SmB  
D.8.04

DAS  
16

12/09/04

6

190

Identify as per dwg & Stock Location: 157

0.00

\*190\*

Packaging

Memo

0.00

Packaging

6 12/9/04

20  
at  
ie

Work Order ID 86475

June-29-12 1:30:11 PM

\*86475\*

Page 4

Item ID: D4545-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Retainer, Inner, LH (Lower)

Stop \*NS2\*

Start Date: 29/06/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

200

QC21- Final Inspection - Work Order Release

0.00

\*200\*

QC

Memo

0.00

Quality Control

12/9/5

ME

12-09-04

# Picklist Print

June-29-12 4:30:44 PM

Page 1

Work Order ID: 86475

Parent Item: D4545-041

Parent Item Name: Retainer, Inner, LH (Lower)

\*86475\*

\*D4545-041\*

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.01.13 new issue DD VER:JLM  
12.02.27 AS PER DWG REV.B DD VER:EC  
as per dwg revC DD VER:EC  
IPP REV:B  
IPP REV:C 12.05.08

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-1 *D4541-1* Bracket		Manufactured	No			100	Each	7.0000	1	10			

\*\*

10/12/08/04

## Location

## Loc Qty

## Loc Code

FG

3

B 86460

6

78764

3

B 87775

GA

4

81260

2

2

84957

2

2

D4542-1

Manufactured No

100

Each

5.0000

1

10

\*D4542-1\*

Retainer, Inner, lh

\*\*

10/12/07/04

## Location

## Loc Qty

## Loc Code

GA

5

81265

5

MS20426AD3-4

Purchased No

145

Each

2,750.000

40

400

\*MS20426AD3-4\*

RIVET

\*\*

388074 (ex)

## Location

## Loc Qty

## Loc Code

ST316

2750

104374

236

110398

2514

240

MS21059L3K

~~MS21059L3K~~

M21061L3K

M122452

B# ~~M121822~~

B# M120242

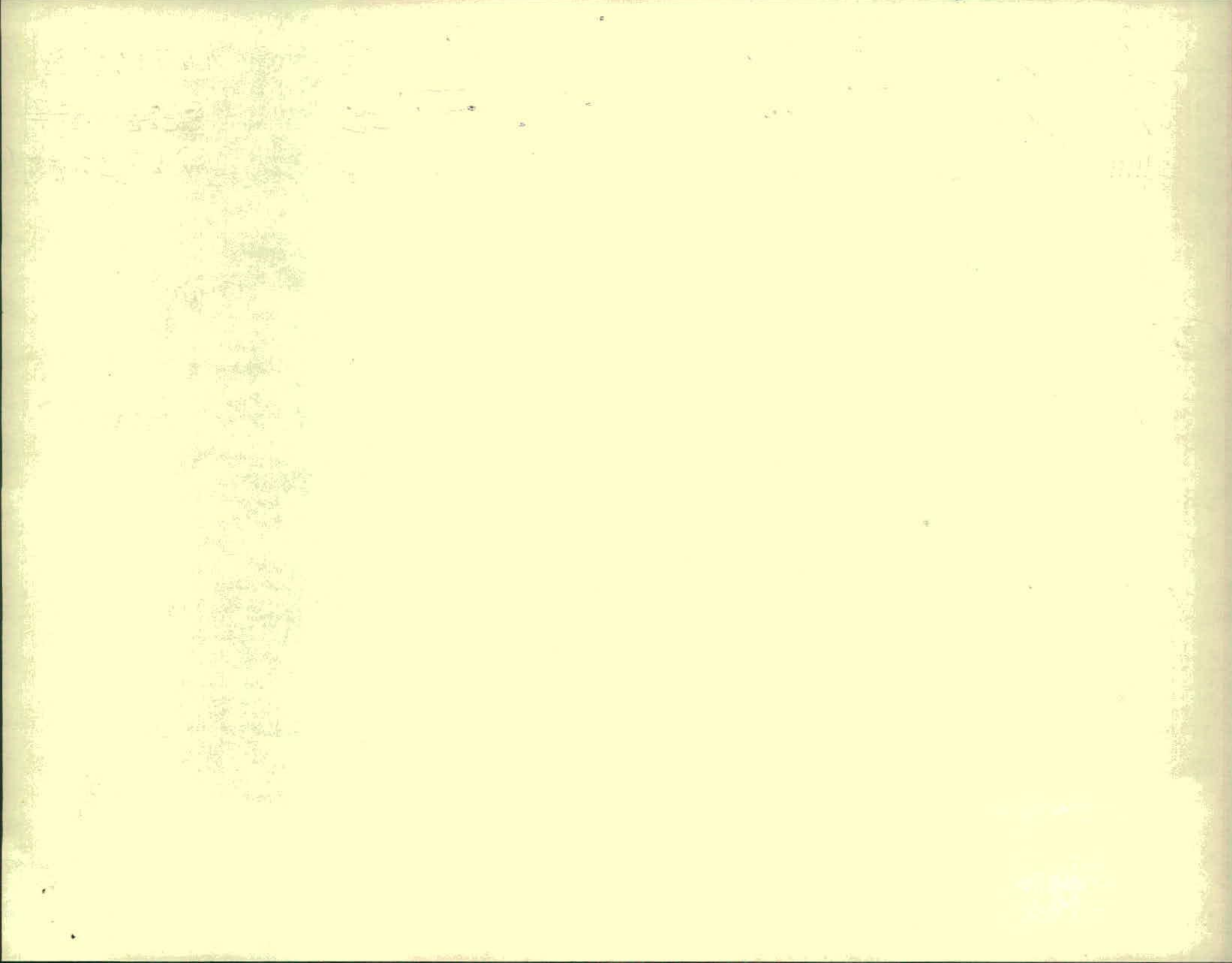
114x  
QTY: 240

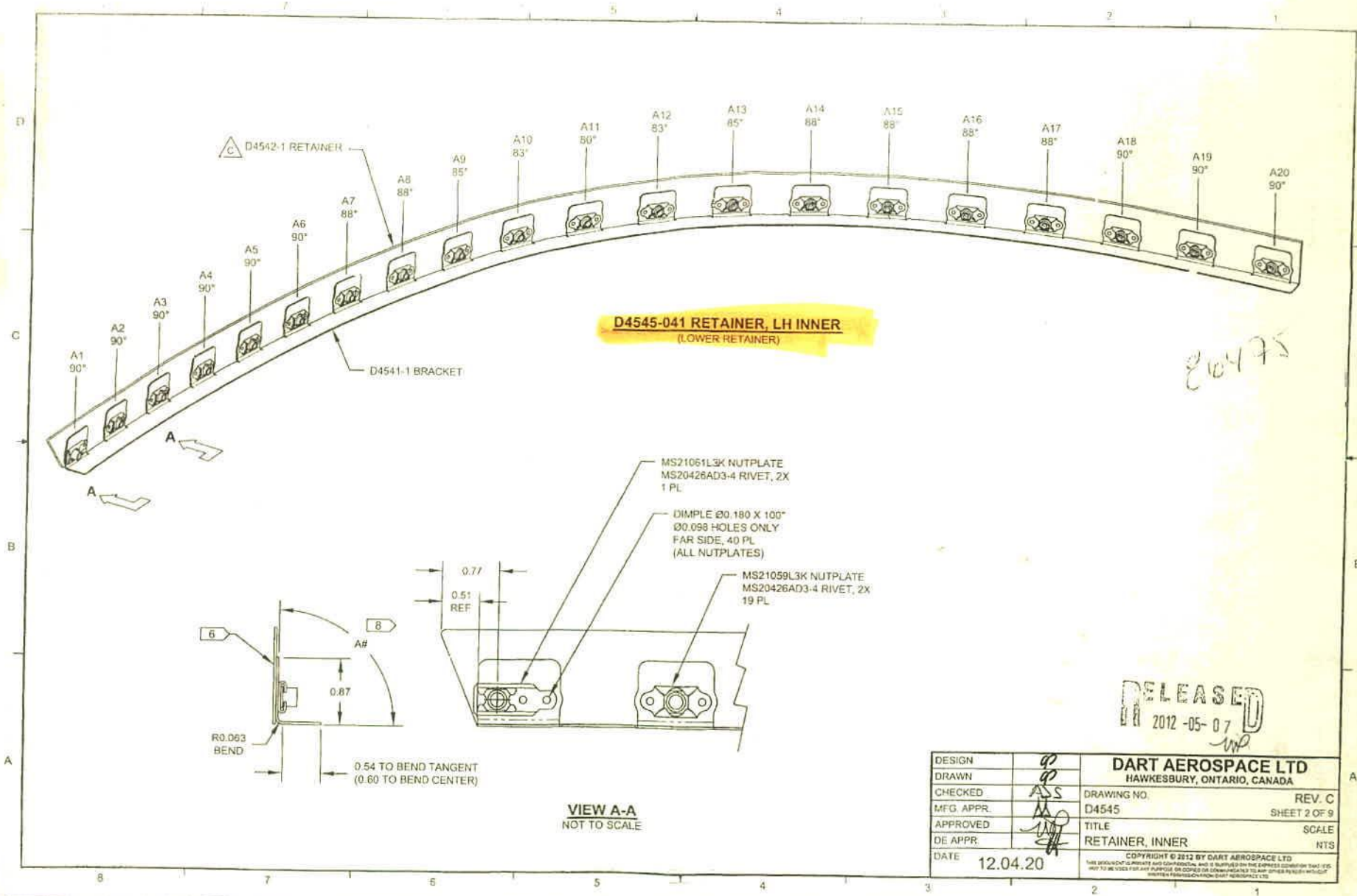
QTY: 6

10/12/07/04

10/12/09/04



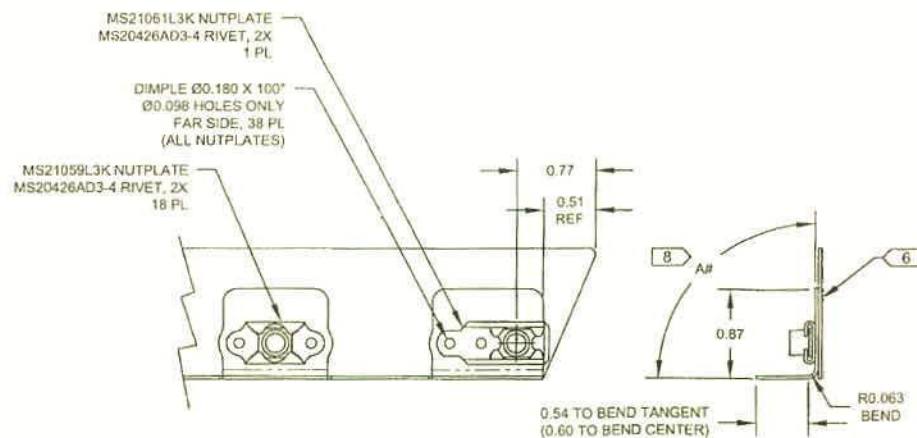
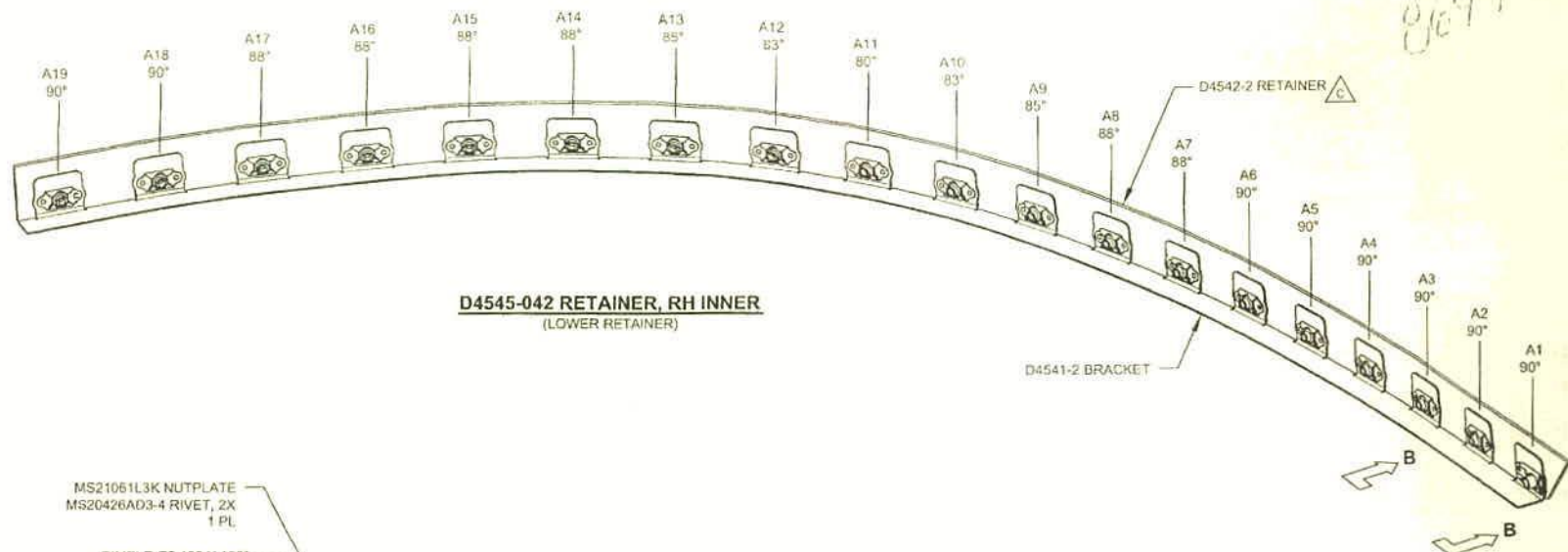




RELEASED  
2012-05-07

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D4545	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
DATE	12.04.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DRAWING IS UNCLASSIFIED AND IS SUPPLIED IN THE PUBLIC DOMAIN. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			

substantia - 1 a



DESIGN	99	<b>DART AEROSPACE LTD</b>	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	MD	D4545	SHEET 3 OF 9
APPROVED	MD	TITLE	SCALE
DE APPR	MD	RETAINER, INNER	NTS
DATE	12.04.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE LTD IS PROHIBITED.</small>	

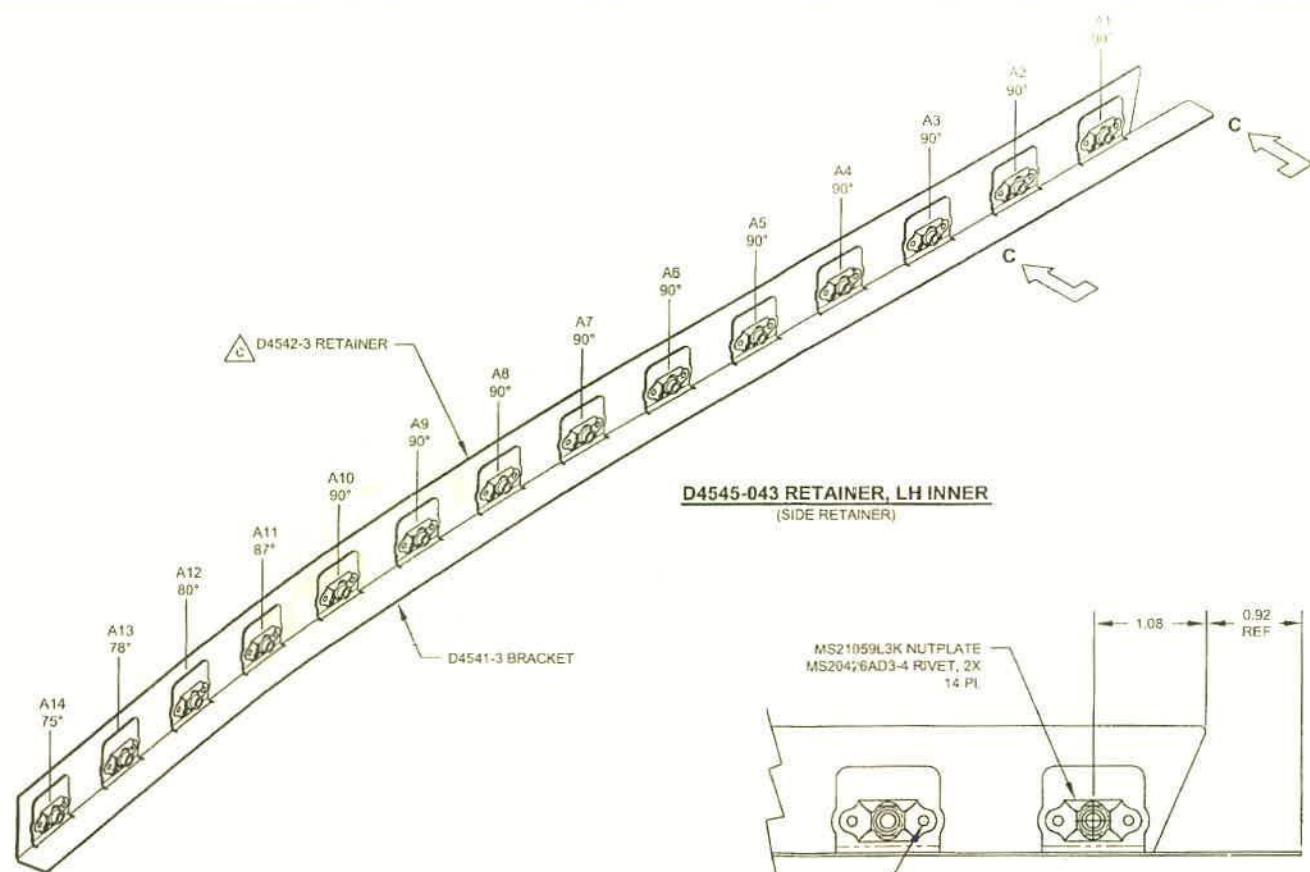
2012-05-07



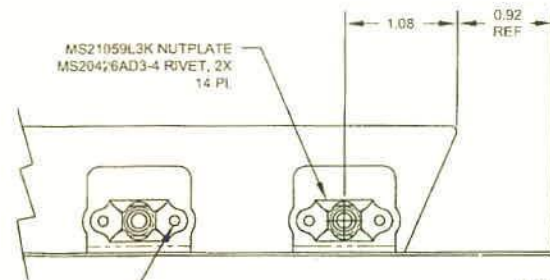


210473

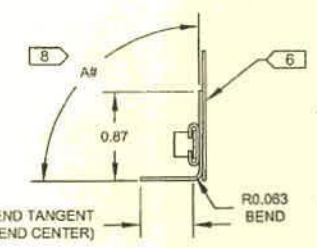
RELEASED  
2012-05-07



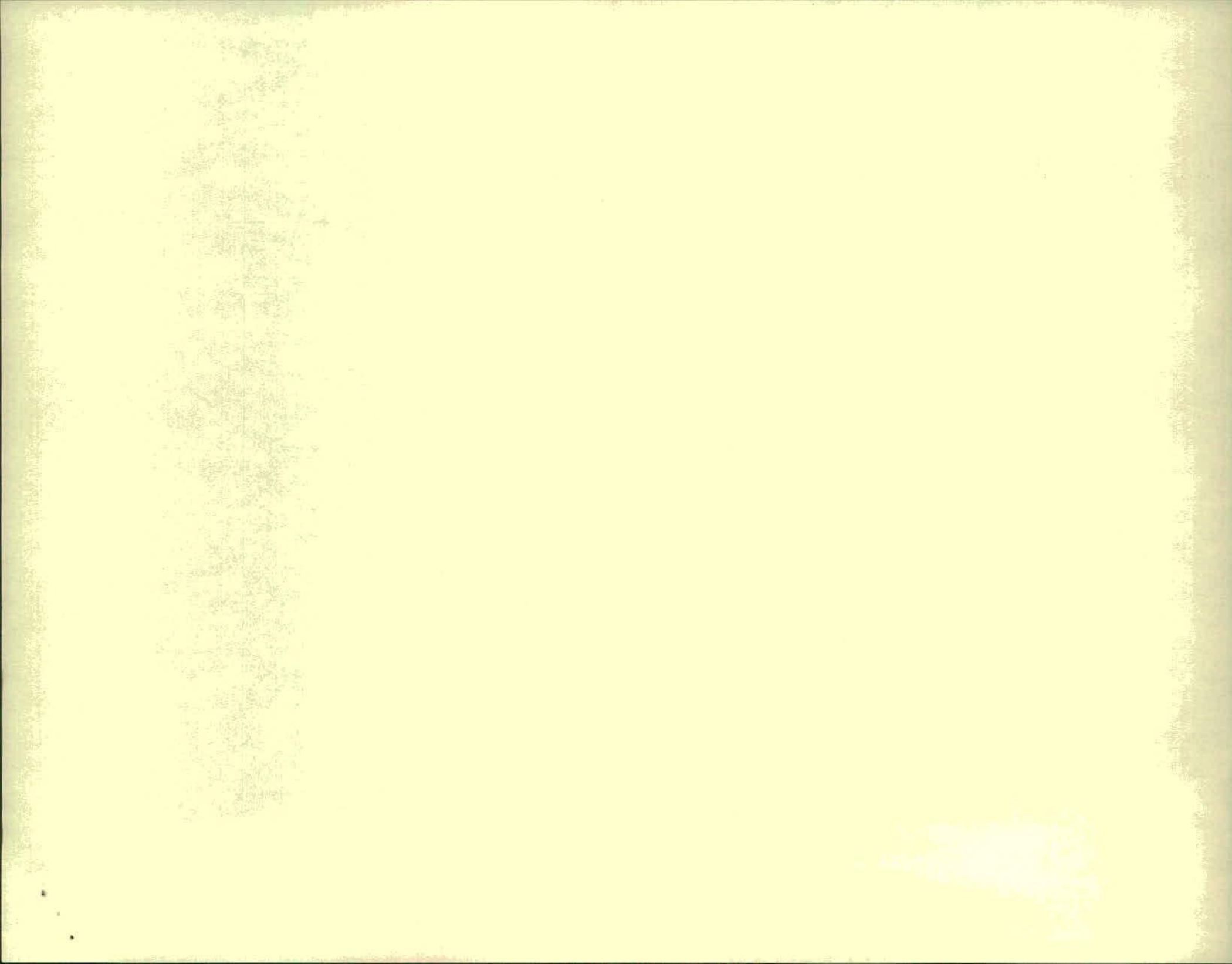
**D4545-043 RETAINER, LH INNER**  
(SIDE RETAINER)



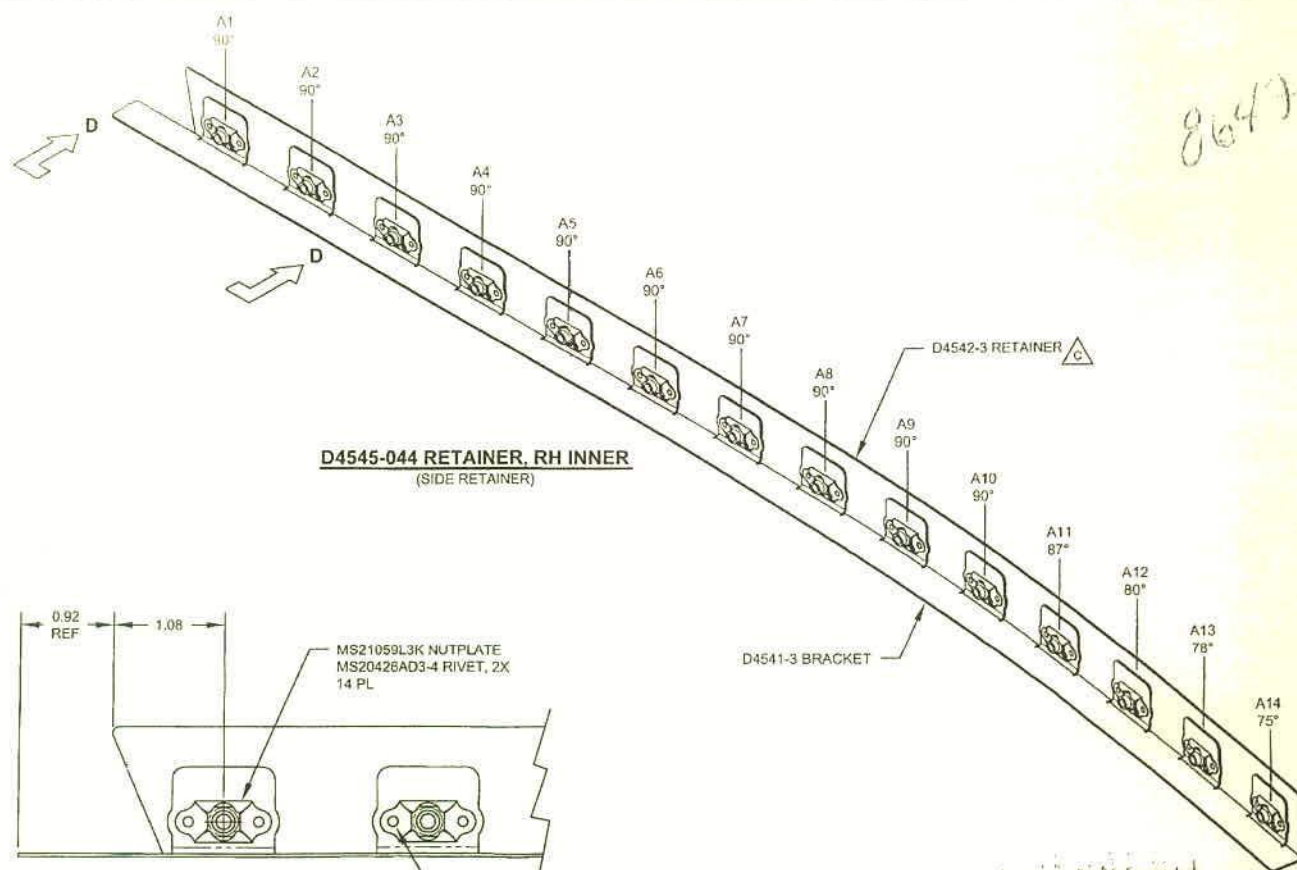
**VIEW C-C**  
NOT TO SCALE



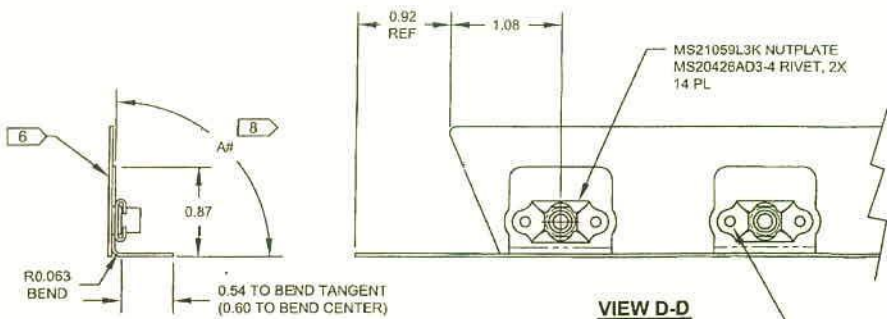
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4545	REV. C
MFG. APPR.	<i>[Signature]</i>		SHEET 4 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER, INNER	NTS
DATE	12.04.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



8047



**D4545-044 RETAINER, RH INNER**  
(SIDE RETAINER)



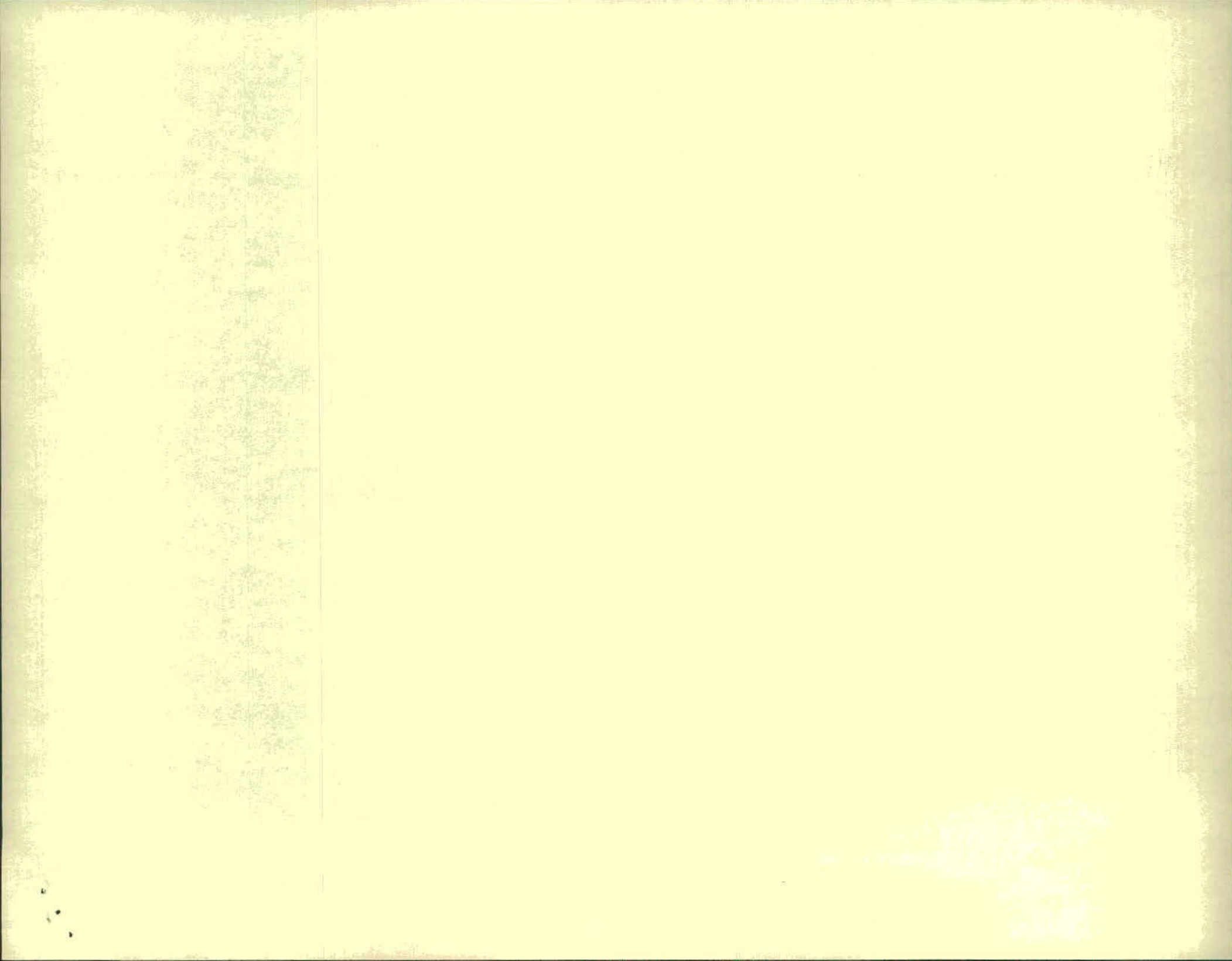
**VIEW D-D**  
NOT TO SCALE

DIMPLE Ø0.180 X 100°  
Ø0.098 HOLES ONLY  
FAR SIDE, 28 PL

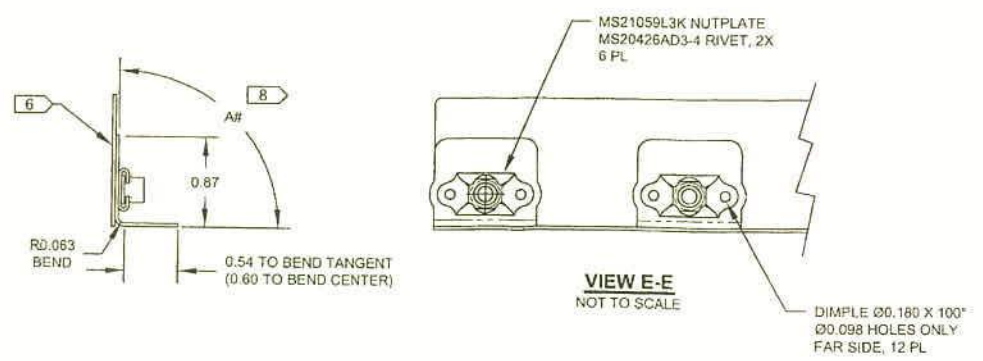
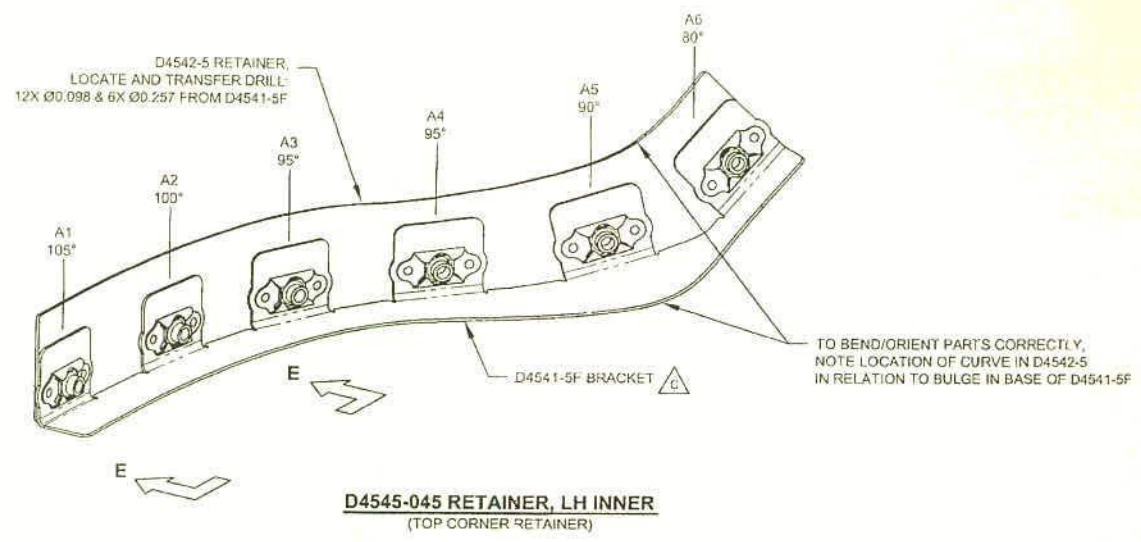
2012-05-03

DESIGN	0	<b>DART AEROSPACE LTD</b>	
DRAWN	0	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	DA	D4545	SHEET 5 OF 9
APPROVED	MA	TITLE	SCALE
DE APPR.	TH	RETAINER, INNER	NTS
DATE	12.04.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	



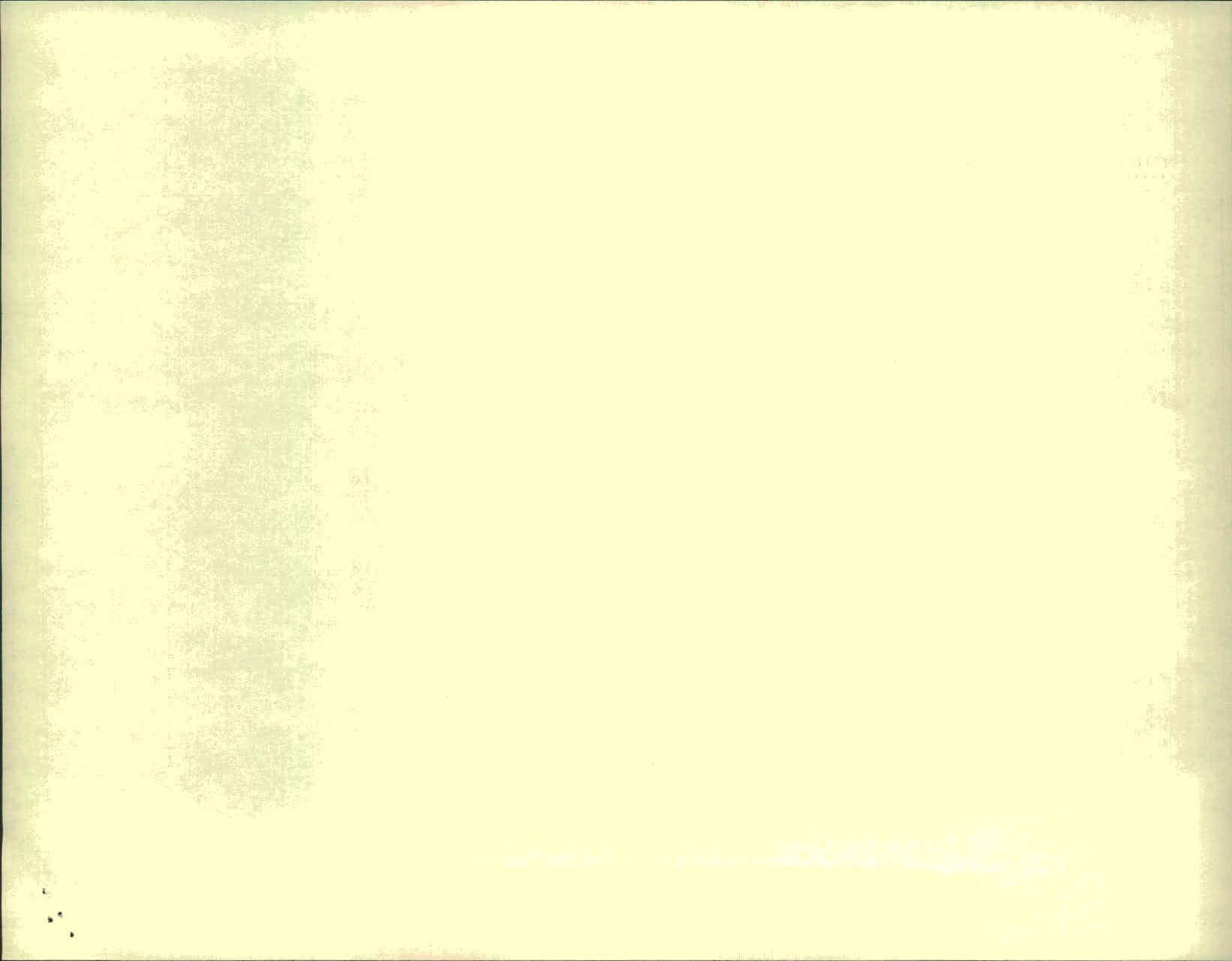


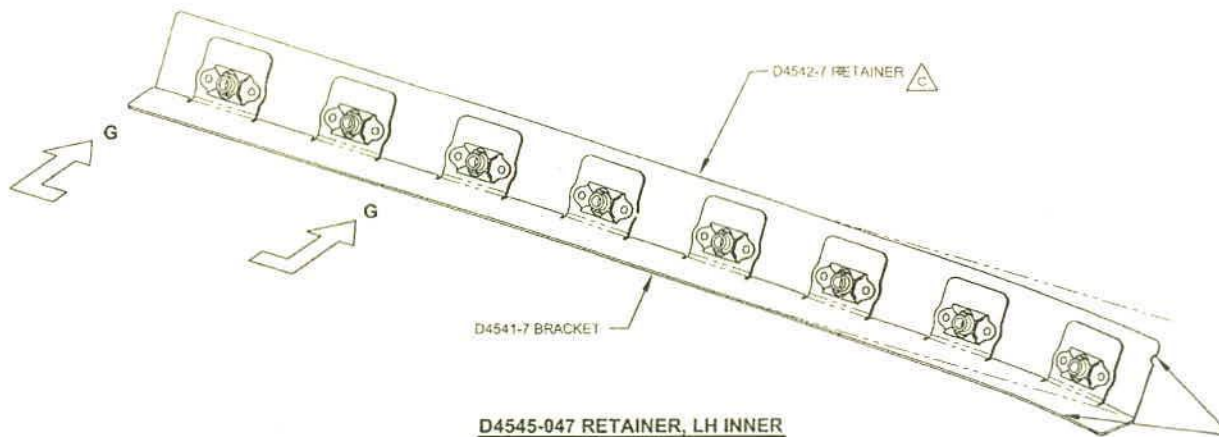
210475



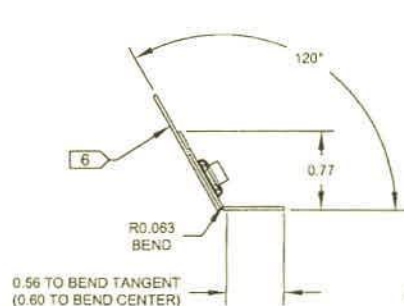
2012-05-07

DESIGN	9	<b>DART AEROSPACE LTD</b>	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D4545	REV. C
MFG. APPR.			SHEET 6 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
DATE	12.04.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED BY THE COMPANY ORIGINATOR THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

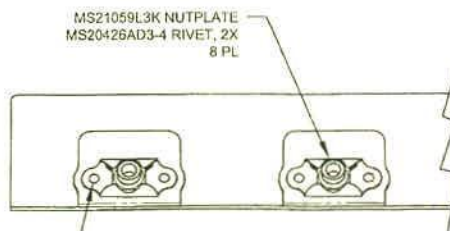




**D4545-047 RETAINER, LH INNER**  
(TOP RETAINER)



DIMPLE Ø0.180 X 100°  
Ø0.098 HOLES ONLY  
FAR SIDE, 16 PL



**VIEW G-G**  
NOT TO SCALE

DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	ASS	DRAWING NO.	REV. C
MFG APPR		D4545	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR		RETAINER, INNER	NTS
DATE	12.04.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD This document is proprietary and confidential. It is supplied on the express understanding that it is not to be used for any purpose other than that for which it was originally intended without the written consent of DART AEROSPACE LTD.</small>	

RELEASED  
2012-05-03

86475



